

Work Order ID 72080

Tuesday, July 19, 2011 9:52:50 AM



Page 1

Item ID:	D3825-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket End)					
Start Date:	7/19/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	7/26/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-07-19	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	Rev A								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825
A/R S.S. Rod Batch: 1415778

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

11.07.21 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PC 11-07-20

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

nl 11 07 21 6

150

Identify as per dwg & Stock Location WA

0.00



Packaging

Memo

0.00

Packaging

SA 11-07-21 26

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/h/21

UMF
11-09-21

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Picklist Print

Tuesday, July 19, 2011 9:52:55 AM

Page 1

Work Order ID: 72080

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 7/19/2011


Required Date: 7/26/2011

Start Qty: 6.00

Required Qty: 6.00


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3  Spacer Bushing		Manufactured	No			100	Each	8.0000	1	6		11.07.20	
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Location	Loc Qty	Loc Code
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WA	8	
70884	8	

D3759-1  Bushing		Manufactured	No			100	Each	173.0000	1	6		11.07.20	
---	--	--------------	----	--	--	-----	------	----------	---	---	--	----------	--

Location	Loc Qty	Loc Code
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WA	171	
69202	171	
WA005	2	
66489	2	

M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	634.8213	2.125	13.42105		11.07.20	
--	--	-----------	----	--	--	-----	---	----------	-------	----------	--	----------	--

Location	Loc Qty	Loc Code
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MAT018	91.83716	
117598	14.13846	
117636	77.6987	
WA	500	
118181	500	
WA007	42.9840906	
116267	36.391372	
116763	6.5927186	

13.42105

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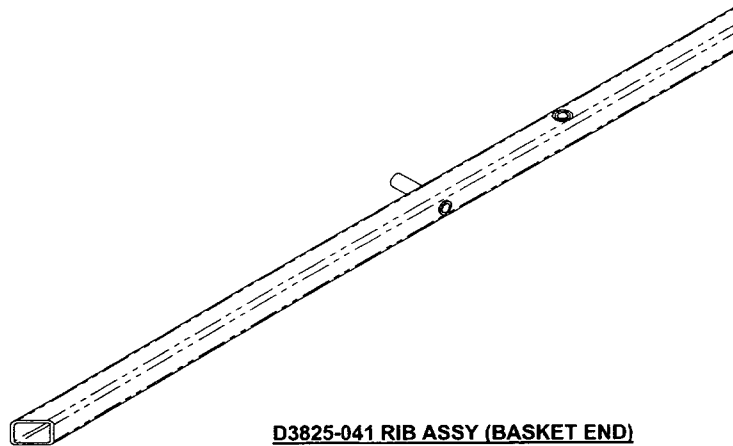
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

STRICTLY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **12080**
PL 11-0719

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	08.09.23
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.23			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. **A**
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET END)** SCALE **NTS**

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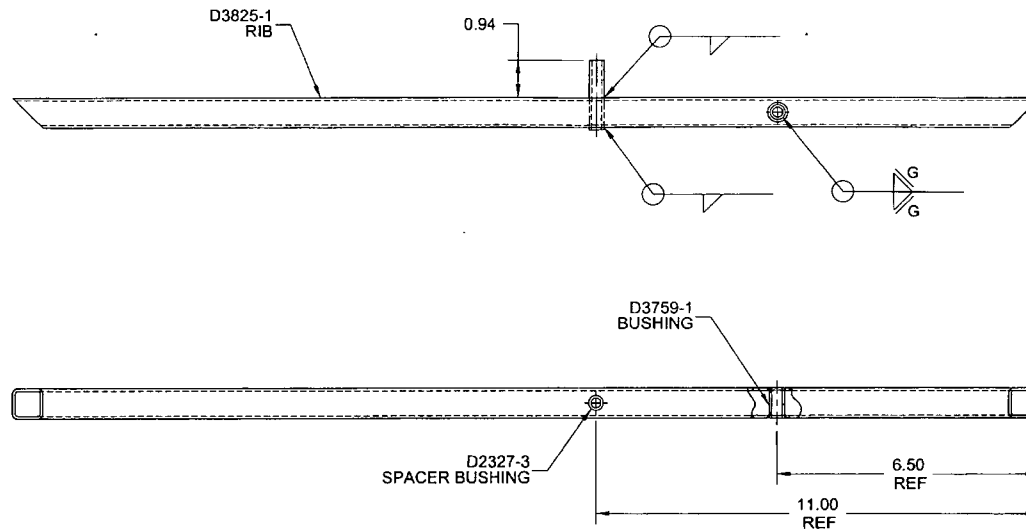
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72080

D3825-041 RIB ASSY (BASKET END)

RELEASED
08/11/18 JWW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/3/18	DRAWING NO. D3825	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE RIB ASSY (BASKET END)	SCALE
DE APPR.			NTS
DATE	08.09.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

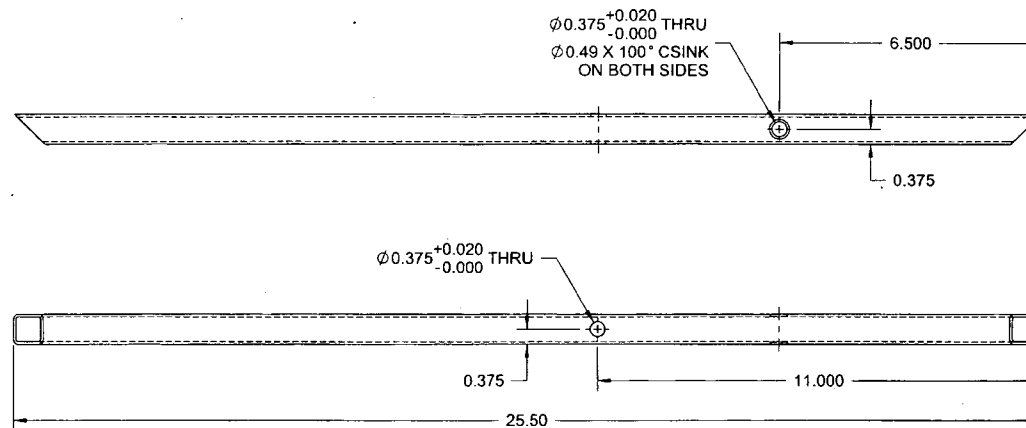
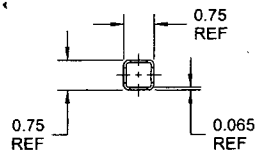
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D3825-1 RIB

72080

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

RELEASED
08/11/18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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